



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 173051



Part No: D350-591-311

Job Qty: 5 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 3/30/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	3/29/18		0.00	0.00	Start Up Large Fab-4		SL
110	Large Fab	5 pcs	3/29/18		0.00	4.96	Large Fab 2		SL
120	QC	5 pcs	3/29/18		0.00	0.00	QC9		SA 18-3-14
130	QC	5 pcs	3/29/18		0.00	0.00	QC5		SA 18-3-14
140	HandFinish	5 pcs	3/29/18		0.00	0.92	HandFinish1		SA 18-3-14
150	QC	5 pcs	3/29/18		0.00	0.00	QC7-2		CPC
180	Large Fab	5 pcs	3/29/18		0.00	4.96	Large Fab 2		SL
190	QC	5 pcs	3/29/18		0.00	0.00	QC10		
200	QC	5 pcs	3/29/18		0.00	0.00	QC5		
210	HandFinish	5 pcs	3/29/18		0.00	0.92	HandFinish1		SA 18-3-14
220	Powdercoat	5 pcs	3/29/18		0.00	1.45	Powdercoat1		BR 18-4-5
230	HandFinish	5 pcs	3/30/18		0.00	0.92	HandFinish3		BE 18-07-05
240	QC	5 pcs	3/30/18		0.00	0.00	QC3		38
250	Packaging	5 pcs	3/30/18		0.00	0.00	Packaging1-3		DAS 9:38
260	QC	5 pcs	3/30/18		0.00	0.00	QC4		6 JUL 17 2018
265	DC	5 pcs	3/30/18		0.00	0.00	DC		9:39 DAS
270	Packaging	5 pcs	3/30/18		0.00	0.00	Packaging3-1		21 JUL 23 2018
280	QC21-FG	5 Ea	3/30/18		0.00	0.00	QC21		9:38

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M138673 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod M138673 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 10:10 OVEN TEMPERATURE: 320 FINISH TIME: 10:40

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

wing walk 5080995.

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Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	10 Ea (2 ea)	90-Start up Operation	S047606
D3219-1	Plate	10 Ea (2 ea)	90-Start up Operation	S047627
D3272-1	Step	5 Ea (1 ea)	90-Start up Operation	S048819
D3065-041	Step Leg Assembly	5 Ea (1 ea)	180-Large Fab	S053783
D3066-1	Spacer	10 Ea (2 ea)	180-Large Fab	S051986
MS20600-AD4W4	Rivet	80 Ea (16 ea)	180-Large Fab	S041171
AN3-35A	Bolt	10 Ea (2 ea)	250-Packaging	S067811
AN4-13A	Bolt	40 Ea (8 ea)	250-Packaging	S055949
AN5-36A	Bolt	10 Ea (2 ea)	250-Packaging	S068656
D2230-3	Mounting Lug	20 Ea (4 ea)	250-Packaging	S083080
D2618	Bushing	10 Ea (2 ea)	250-Packaging	S049859
D2856-400-720	Abrasion Strip 4" X 7.20"	10 Ea (2 ea)	250-Packaging	S082563
D3235-1	Mounting Lug	10 Ea (2 ea)	250-Packaging	S05363
D3278-041	Support Assembly	5 Ea (1 ea)	250-Packaging	S0688
MS21042L3	Nut	10 Ea (2 ea)	250-Packaging	S078167
MS21042L4	Nut	40 Ea (8 ea)	250-Packaging	S084365
MS21042L5	Nut	10 Ea (2 ea)	250-Packaging	S058779
NAS1149D0363J	Washer	20 Ea (4 ea)	250-Packaging	S05267
NAS1149D0463J	Washer	80 Ea (16 ea)	250-Packaging	S062379
NAS1149D0563J	Washer	20 Ea (4 ea)	250-Packaging	S086662
DS19410-011		88		S076688
				SD 88446
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	10	23	0
	D3219-1	10	44	0
	D3272-1	5	0	0
180-Large Fab	D3065-041	5	12	0
	D3066-1	10	30	0
	MS20600-AD4W4	80	1,841	0
250-Packaging	AN3-35A	10	122	0
	AN4-13A	40	467	0
	AN5-36A	10	148	0
	D2230-3	20	65	0
	D2618	10	234	0
	D2856-400-720	10	97	0
	D3235-1	10	14	0
	D3278-041	5	8	0
	MS21042L3	10	3,411	0
	MS21042L4	40	998	0
	MS21042L5	10	877	0
	NAS1149D0363J	20	3,425	0
	NAS1149D0463J	80	2,258	0
	NAS1149D0563J	20	1,330	0
Part Specifications				
Specifications could not be found.				

Plex 2/26/18 8:38 AM Dart.Gagnon.Michelle



Container No: S049392



Part: D350-591-311

Job No: 173051

Serial No/Batch: S049392

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/08/18

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

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Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

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